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D350-591-311
Job Sheet 168323



Part No: D350-591-311

Job Qty: 3 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aeroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

AIR BUS

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	11/16/17	11/16/17	0.00	0.00	Start Up Large Fab-2		S.L 11/13/17
110	Large Fab	3 pcs	11/16/17	11/16/17	0.00	2.97	Large Fab 2		S.L 11/14/17
120	QC	3 pcs	11/16/17	11/16/17	0.00	0.00	QC9		PD 11-16
130	QC	3 pcs	11/16/17	11/16/17	0.00	0.00	QC5		PD 11-16
140	HandFinish	3 pcs	11/16/17	11/16/17	0.00	0.55	HandFinish1		2017-11-16 JSL
150	QC	3 pcs	11/16/17	11/16/17	0.00	0.00	QC7		PD 11-16
180	Large Fab	3 pcs	11/16/17	11/16/17	0.00	2.97	Large Fab 2		S.L 11/17/17
190	QC	3 pcs	11/16/17	11/16/17	0.00	0.00	QC10		
200	QC	3 pcs	11/16/17	11/16/17	0.00	0.00	QC5		
210	HandFinish	3 pcs	11/16/17	11/16/17	0.00	0.55	HandFinish1		2017-11-20 JSL
220	Powdercoat	3 pcs	11/16/17	11/16/17	0.00	0.87	Powdercoat1		PD 11-21
230	HandFinish	3 pcs	11/17/17	11/17/17	0.00	0.55	HandFinish3		PD 11-27
240	QC	3 pcs	11/17/17	11/17/17	0.00	0.00	QC3		
250	Packaging	3 pcs	11/17/17	11/17/17	0.00	0.00	Packaging1		
260	QC	3 pcs	11/17/17	11/17/17	0.00	0.00	QC4		
265	DC	3 pcs	11/17/17	11/17/17	0.00	0.00	DC		
270	Packaging	3 pcs	11/17/17	11/17/17	0.00	0.00	Packaging3		
280	QC21-FG	3 Ea	11/17/17	11/17/17	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 3:15 OVEN TEMPERATURE: 300 FINISH TIME: 3:45

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
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9- Start up Operation

180-Large Fab

250-Packaging

D3067-1	3	38	0	0
D3219-1	6	37	0	0
D3272-1	3	33	0	0
D3065-041	3	11	0	0
D3066-1	6	28	0	0
D3067-1	3	38	0	0
MS20600-AD4W4	48	682	0	0
✓ AN3-35A 5012538	6	72	0	0
✓ AN4-13A 5012533	24	453	0	0
✓ AN5-36A 5012528	6	102	0	0
✓ D2230-3 5012542	12	321	0	0
✓ D2618 5012542	6	127	0	0
✓ D2856-400-720 5012539	6	106	0	0
✓ D3235-1 5012526	6	163	0	0
✓ D3278-041 5012525	3	29	0	0
✓ MS21042L3 5012524	6	1,230	0	0
✓ MS21042L4 5012523	24	1,586	0	0
✓ MS21042L5 5012522	6	413	0	0
NAS1149D0363J 5012524	12	597	0	0
NAS1149D0463J 5012520	48	1,386	0	0
5012579X4 ✓ NAS1149D0563J FM13820944 12 X8	12	1,347	0	0

Part Specifications

Specifications could not be found.

✓ MS20600-AD4W4 ✓ - FM 138441-40 Qty 48

Plex 11/13/17 1:04 PM dart.poulin.mario

* X D3065-041 - F166514 Qty 3

✓ D3066-1 - F165744 Qty: 6

✓ 3067-1 - F165725 Qty 3

500942, X3



S009421



Heli - Access - Step LH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 - 591 - 311

Revision:

Operation:

Change No:

Large Fab

Dart Aerospace Ltd.
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Mfg Date: 11/13/17
Job No: 168323

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-38A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.